

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-022346**Date Inspected:** 13-Mar-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Kelly Leavitt, was present during the times noted above for random observations relative to the work being performed.

Bay 14

This QA Inspector observed the following work in progress for Bay 14.

ZPMC was using the Shielded Metal Arc Welding (SMAW) process.

ZPMC QC is identified as Shen Jian Bo, CWI Shi Zhi.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

Components; OBG 13AW

PCMK: DP3138

Weld No: 001,002,003,004

Welder: 066398

WPS-B-P-2112

Components; OBG 14 E

PCMK: SEG3013

Weld No: 001,009

Welder: 067829

WPS-B-P-2214-B-U4b-FCM

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Components; OBG 13 W

PCMK: SEG3013AH

Weld No: 001

Welder: 045213

WPS-B-4212-B-U2-2

Components; OBG 14 E

PCMK: SEG3013J

Weld No: 006

Welder: 047864

WPS-B-P-2213-B-U4b-FCM

Components; OBG 14 E

PCMK: SEG3013N

Weld No: 157,152,162

Welder: 203871

WPS-B-P-2213-B-U4b-FCM

This QA Inspector observed the following work in progress for Bay 14.

ZPMC was using the Flux Core Arc Welding (FCAW) process.

ZPMC QC is identified as Shen Jian Bo, CWI Shi Zhi.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

Components; OBG 13 W

PCMK: SEG3013F

Weld No: 050,051

Welder: 050105

WPS-B-T-2133-ESAB

Components; OBG 14 E

PCMK: SEG3013H

Weld No: 048,049

Welder: 045143

WPS-B-T-2133-ESAB

Components; OBG 13 W

PCMK: SEG3013R

Weld No: 006

Welder: 066421

WPS-B-T-2232-ESAB

This QA Inspector observed the following work in progress for Bay 14.

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ZPMC was using the Shielded Metal Arc Welding (SMAW) process.

ZPMC QC is identified as Zhong Yong Gung, CWI Liang Biao.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

Components; OBG 13AE

PCMK: SEG3009C

Weld No: 002,003

Welder: 070006

WPS-B-P-2213-B-U2-FCM-1

Components; OBG 13E

PCMK: SEG3009J

Weld No: 001,003

Welder: 069493

WPS-B-P-2213-B-U2-FCM-1

Components; OBG 13E

PCMK: SEG3007AH

Weld No: 007

Welder: 037748

WPS-B-P-2214-TC-U4b-FCM-1

Components; OBG 13E

PCMK: SEG3007AB

Weld No: 004

Welder: 094772

Weld Repair No. B-WR20397

WPS-345-SMAW-1G(1F)-FCM-Repair-1

Components; OBG 13E

PCMK: SEG3007AV

Weld No: 030

Welder: 034013

Weld Repair No. B-WR19454

WPS-345-SMAW-4G(4F)-FCM-Repair-1

Components; OBG 13E

PCMK: SEG3019U

Weld No: 003

Welder: 215553

Weld Repair No. B-CWR2822

WPS-345-SMAW-2G(2F)-FCM-Repair-1

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Components; OBG 13E
PCMK: SEG3019D-1
Weld No: 323
Welder: 216086
Weld Repair No. B-WR2677
WPS-345-SMAW-3G(3F)-FCM-Repair-1

This QA Inspector observed the following work in progress for Bay 14.
ZPMC was using the Flux Core Arc Welding (FCAW) process.
ZPMC QC is identified as Zhong Yong Gung, CWI Liang Biao.
Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).
Listed below are the locations that were identified by this QA inspector.

Components; OBG 13 E
PCMK: SEG3007AH
Weld No: 166
Welder: 055491
WPS-B-T-2232-ESAB

Components; OBG 13 E
PCMK: SEG3007Y
Weld No: 352,362
Welder: 050242
WPS-B-T-2231-ESAB

Components; OBG 13 E
PCMK: DP3001
Weld No: 005,106
Welder: 055564
WPS-B-T-2232-ESAB

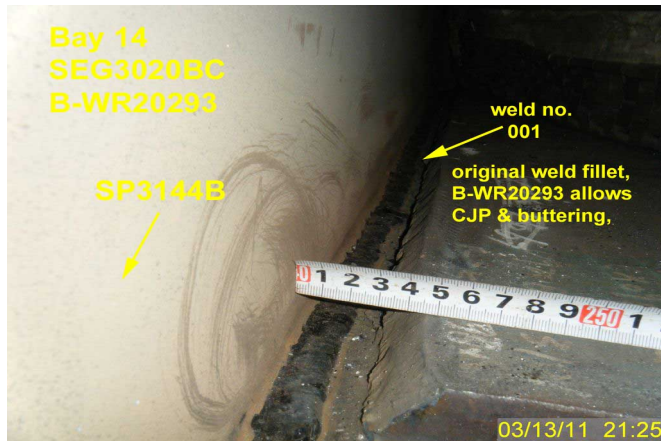
Components; OBG 13 E
PCMK: SEG3019K
Weld No: 219,221,223,335,227,229,231
Welder: 051356
WPS-B-T-2233-ESAB

This QA Inspector performed document review for information requested by James Devy, and the Office of Structural Materials. This information request addresses OBG 14 west and 14 east anchorage plate assembly AP3031 and AP3032. This QA Inspector performed random visual inspections of the weld size, cope hole size and condition listed in the information request form. It appears to this QA Inspector ZPMC has completed the welds as referenced in the request. This QA Inspector took random photographs of the welds and copies of the photographs have been placed in "TC-RFI Documentation" folder located on Team China common Z drive.

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Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

No significant conversations

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact James Devey 1500026784, who represents the Office of Structural Materials for your project.

Inspected By:	Leavitt,Kelly	Quality Assurance Inspector
Reviewed By:	Riley,Ken	QA Reviewer
